

# BONIPUR D-65

## ONE-COMPONENT POLYURETHANE ADHESIVE



- D4 class water resistance
- For wood with high moisture content
- Good initial tack
- Very good adhesion
- High bonding strength
- Long open time
- Ability of bonding bituminous board to styrofoam
- Ageing resistant
- Wide range of applications
- Solvents free

### PRODUCT DESCRIPTION

Polyurethane, one-component adhesive with addition of modifiers of D4 water resistance class according to the Standard PN-EN 204. Bond in full strength demonstrates good adhesion to wooden surfaces. Adhesive is expansive, in contact with humidity gets foamy and its volume increases.

### TECHNICAL CHARACTERISTICS

Base	polyurethane
Color	brown
Odor	proper to type
Solids content	100 %
Application temperature	15 – 25 °C
Open time	50 – 90 minutes*
Viscosity	8000 ± 500 mPa·s
Application rate	100 – 700 g/m <sup>2</sup>
Pressing pressure	0,1 – 0,5 N/m <sup>2</sup>
Pressing time	2 h – 2 h 30 min.
Wood humidity	up to 25 %
Air relative humidity	60 – 70%

\* Open time depends on temperature and humidity. The given values were measured in laboratory conditions.

### APPLICATION

Recommended for professional bonding of:

- wooden elements, which often are exposed to moisture and diverse weather conditions
- elements of garden furniture
- wooden fence
- stairs
- bituminous board to styrofoam.

It enables bonding wood to metal, concrete, natural and artificial stone.

### DIRECTIONS FOR USE

BONIPUR D-65 and materials to be bonded warm up to minimum 15°C. Surfaces must be clean, dry, oil, fats and dust free.

Apply the adhesive on one side with use of spatula, feeding vessel, applicator, hand roller or machine (using nozzle or rollers).

After applying join materials and press evenly.

It is recommended to put the water stream on the surface (10 g/m<sup>2</sup>) just before joining two surfaces. To achieve correct bonding strength it is necessary to use pressure.

Full strength of the adhesive bond is reached after 24 hours.

### CLEANING

Fresh stains can be removed from tools with acetone. Cured adhesive can be removed only mechanically.

### STORAGE

Adhesive should be stored in hermetically closed containers, at temperature +10°C ÷ +25°C. Product stored under conditions other than required loses its properties and is not suitable for use. Find detailed information in product Safety Data Sheet.

### SHELF LIFE

6 months from date of production in unopened packaging.

### PACKAGING

Plastic packaging: 1kg, 5kg, 10kg, 220kg, 1000kg.

### HEALTH AND SAFETY RECOMMENDATIONS

Observe the industrial hygiene precautions. Avoid contact with eyes and skin. Use in well ventilated areas. Keep away from children. Product is classified as dangerous according to the regulations – details are given in Safety Data Sheet.



Issue 9, January 2020r. This issue supersedes all previous technical information on this product.

**NOTE:** The technical information, recommendations and other statements contained in this document are based upon tests or experience that our company believes are reliable, but the accuracy or completeness of such information is not guaranteed. The company cannot accept any responsibility for loss or damage that may result from the use of this information, due to the possibility of variations of processing or working conditions and of workmanship outside our control. **Users are advised to confirm the suitability of this product by their own tests.**

